

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004193**Date Inspected:** 20-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang Bao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

This report serves to document the events occurring on this date at the following location. Caltrans Quality Assurance (QA) Inspector Robert Vatcher arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

OBG Assembly Bay II

3AE- QA observed welding in the 3G position by FCAW process at LD002-002 weld 43 to FL-2 SEG14B04333 Panel Point 22. QA observed back grinding for further weld metal depositing on the opposite side. AB/ F QC personnel Wang Chao was present to observe and document the welding operation.

5BW- QA arrived at side plate to side plate stiffener fit up operation for SOP748-001, SP510-001 & SZP470-001. QA met with ZPMC QC personnel Shen Fu You & Wu Shi Gao due to the root openings being wider than 5 millimeters. Fu You mentioned that a Welding Repair Report (WRR) would be issued to address the weld metal/ base metal build up required to continue with those affected gaps. QA concurred. No welding as of this time.

North Bay of OBG Assembly-

QA observed diaphragm plate to deck panel joining included only plate grinding for fit-up preparation for deck panels DP162-001, DP216-001. QA observed that tacking of diaphragm plate to deck panel DP189-001 had been previously performed. No other welding operations at this time.

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Preheating being performed in preparation for joining SP123-01 to SP096-001 for subsequent SAW operation. No immediate issues observed by QA.

North Sub-Assembly Area (Outside of OBG)

No activity this date this location.

The above mentioned items, as observed and documented by QA, appear to be in conformance with the contract documents.

Summary of Conversations:

No relevant conversations this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Vatcher,Robert	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
